

Work Order ID 76092

76092

Page 1

November-07-11 7:56:02 AM

Item ID: D2279 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 07/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2279 | Rev D | | | | | | | | |

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 20 0 Jm 12-6-14
 FLOW CNC Waterjet 1-Cut as per Dwg D 2279 Dwg Rev: D Prog Rev: D 2-
2024.040 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 20 0 Jm 12-6-14
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 counts
Scrubbed fzo
 Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | NC BRAKE | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | Form As per Dwg D2279 | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | QC5- Inspect part completeness to step on W/O | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | | 0.00 | | | | | | | |
| *150* | Chemical Conversion Coat per QSI005 4.1 | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

Handwritten notes and stamps:
 12/06/19
 20
 20
 12-6-25

| W/O: | | WORK ORDER CHANGES | | | | | |
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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 20X | | | 12/07/11 |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: <u>6A</u> Memo | 0.00 0.00 | | | | 20X | | | 12/07/11 |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | CK | | | 12/7/12 |

11/20/11

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NOTE: Date & initial all entries

Picklist Print

November-07-11 7:56:06 AM

Page 1

Work Order ID: 76092

76092

Parent Item: D2279

D2279

Parent Item Name: Step Spacer

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A New Issue 05-11-07 JLM
IPP Rev: B Now on Waterjet 06-07-03 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M2024T3S.040

Purchased

No

100

sf

76.8184

0.147

3.094737

M2024T3S 040

**

Jm 12-6-14

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

76.818421

117684

76.818421

120605

120605.

| W/O: | | WORK ORDER CHANGES | | | | | |
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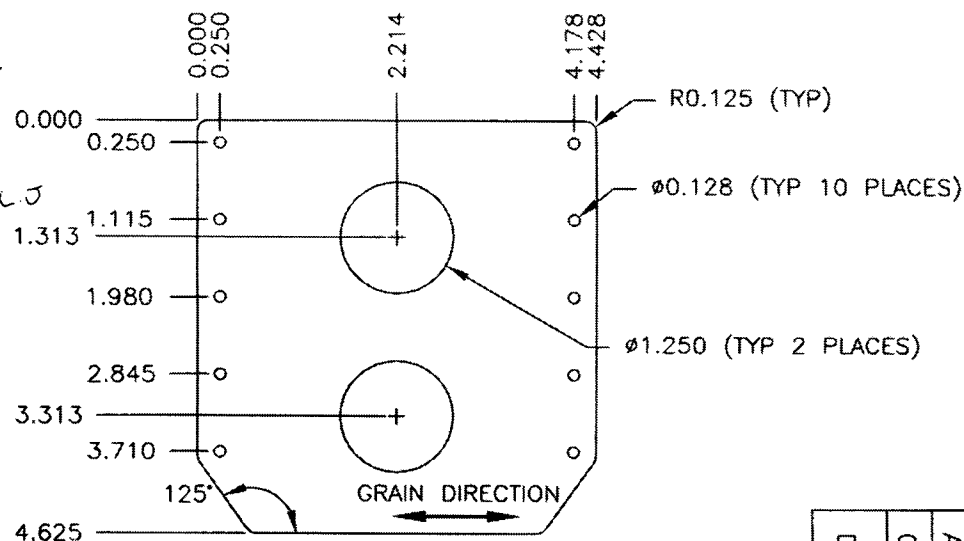
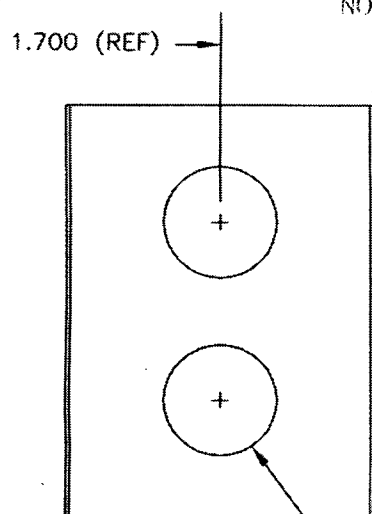
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CA COPY

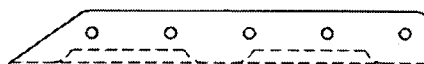
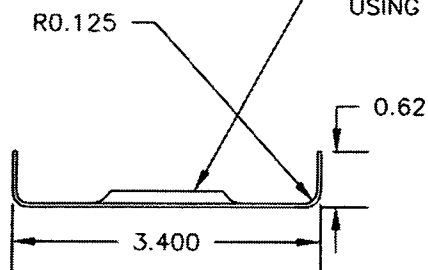
| | | | |
|----------------------|--------------------------------------|--|--------------------------|
| DESIGN B/W | DRAWN BY <i>JP</i> | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>JP</i> | DRAWING NO. D2279 | (REV. D) SHEET 1 OF 1 |
| DATE 98.10.05 | TITLE STEP SPACER SCALE 1:2 | | |
| A | 94.10.13 | NEW ISSUE | |
| C | 94.11.15 | 0.588 WAS 1.607 AND 3.861 WAS 4.881 | |
| D | 98.10.05 | 4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912 | |

NO 76092 M.C.S.
11/11/07 13



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



UNDER REVIEW

98-1008 DS

0103.15 4P
DESIGN OK, BUT CHECK WITH
THE IRONING MANUFACTURE

OK
11:04
1/14/12

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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